

Date: Thursday, 06/11/2008 3:47:02 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TAIL LIGHT FAIRING
Job Number	: 43266		
Estimate Number	: 12710		
P.O. Number	:	Part Number	: D412750142
This Issue	: 06/11/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: N/A
First Issue	: / /	Project Number	: N/A
Previous Run	: 42241	Drawing Revision	: A
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 17/11/2008
Checked & Approved By	: <u>JUD 08.11.06</u>	Qty:	1 Um: Each
Comment	: est revA 06.09.22 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for JUD 08.11.21



Comment: Photocopy bluefile & type labels per PPP D412-750-142 CHG001

Soslu21

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D3484042	Tail Light Fairing Assembly, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

TAIL LIGHT FAIRING, RH

B43277

SS 08/11/21 (X1)

4.0	AN33A	Bolt
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Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Batch:

M116062

New Batch

SS 08/11/21 (X1)

5.0	AN960JD10	Washer
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Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Washer

Batch:

M109059

SS 08/11/21 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 06/11/2008 3:47:02 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 43266

Part Number: D412750142

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

**** Ensure part is a R/H as per dwg ****

Sosluhi **FILED**

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-750-142

Location:

PPP Rev: A

CS/4/21

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/21 **MF**

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
08-11-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

- 3.8 Fasten the D3484-041/-042 Tail Light Fairing complete with A2064-1683 Tail Light Assembly to the tailboom using the provided (10) AN3-3A bolts into the tailboom's existing holes. Torque bolts 15-25 lb-in (1.7-2.8 N-m). Refer to Figure 1, Detail A.

4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the installation of the D412-750-141/-142 Tail Light Fairing Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-750-141	0.13 lb	6.0 in	0.78 lb-in	296.1 in	38.49 lb-in
<i>Tail Light Fairing Kit, LH</i>	0.06 kg	0.2 m	0.01 kg-m	7.5 m	0.45 kg-m
D412-750-142	0.13 lb	6.0 in	0.78 lb-in	296.1 in	38.49 lb-in
<i>Tail Light Fairing Kit, RH</i>	0.06 kg	0.2 m	0.01 kg-m	7.5 m	0.45 kg-m

5.0 PARTS LIST

Qty – 141	Qty – 142	Part Number	Description
X		D412-750-141	TAIL LIGHT FAIRING KIT, LH
	X	D412-750-142	TAIL LIGHT FAIRING KIT, RH
1		D3484-041	TAIL LIGHT FAIRING ASS'Y, LH
	1	D3484-042	TAIL LIGHT FAIRING ASS'Y, RH
10	10	AN3-3A	BOLT
10	10	AN960JD10	WASHER

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43264

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Revision: **A**
Date: 05.11.29